

4/02

|   |                                   |             |
|---|-----------------------------------|-------------|
| <b>DART AEROSPACE LTD</b>                   | <b>Work Order:</b>                | 20081A      |
| <b>Description:</b> Bearpaw Kit (19" x 24") | <b>Part Number:</b>               | K10008      |
| <b>Dwg:</b> D2432 Rev. F3                   | <b>Qty:</b> 16 <del>20</del> Kits | 4           |
| <b>Ref:</b> K10008 Rev. E                   |                                   | Page 1 of 1 |

| Step | Location                      | Procedure   | By      | Date                 | Qty         |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
|------|-------------------------------|---|---------|----------------------|-------------|-------|---|-----------|----------------|--------|----|-------|--------------|--------|---|--------|-------------|--------|---|-------|-------|---------|----|-------|--------|--------|---|-----------|----------------|--------|----|---------|------|--------|----|---------|------|--------|----|------------|--------|--------|----|------------|--------|--------|----|-----------|-------------|--------|---|-------------------------------|--|--|----|----------|----|
| 1    | DC                            | Issue Traveler<br><b>Note: (1) K10008 Kit consists of Qty (2) D2432F<br/>Dwg not required</b>   | HJ      | 03.12.16             | 20          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 2    | DC                            | Photocopy bluefile: K10008<br>D206-559-013<br>D350-578-011<br>D315-670-011<br>D427-659-011<br>and create labels per PPP K10008 <b>CHG006</b><br><b>(Bag Bluefiles separately)</b>   | HJ      | 03.12.19<br>04.01.15 | 10<br>10    |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 3    | GA                            | <b>Cut 2 blanks per (1) K10008 Kit</b><br>Cut blank: 20.00" x 24.00" x 1.00" thick<br>Material: Black UHMW 1"<br>(MUHMWB10) Batch: M14320<br>M1441  | R.J     | 04.01.08             | 20          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 4    | MV                            | Inspect material for defects or damage prior to machining   | SL      | 04.01.16             | 16          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 5    | MV                            | Machine as per Folio D2432 and Dwg D2432  | SL      | 04.01.16             | 16          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 6    | QC2                           | Inspect parts as they come off the CNC machine  | SL      | 04.01.16             | 16          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 7    | MV                            | Deburr  | SL      | 04.01.16             | 16          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 8    | QC8 & 5                       | Second inspection   | ML      | 04.01.15             | 16          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 9    | KP                            | <b>Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3)</b><br><table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B19540</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B19599</td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B20081</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B20089B</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B19615</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B20090</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>B18806</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>M13437</td></tr><tr><td>12</td><td>AN960JD416</td><td>Washer</td><td>M12692</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table> | Qty     | Part Number          | Description | Batch | 6 | D2182B050 | Rubber Cushion | B19540 | 12 | D2274 | Radius Block | B19599 | 2 | D2432F | 24" Bearpaw | B20081 | 6 | D2438 | Clamp | B20089B | 12 | D2529 | Washer | B19615 | 6 | D2732-050 | Rubber Cushion | B20090 | 12 | AN4-15A | Bolt | B18806 | 12 | AN4-17A | Bolt | M13437 | 12 | AN960JD416 | Washer | M12692 | 24 | AN960JD416 | Washer | M13719 | 12 | MS21042L4 | Nut (or -4) | M13276 | 1 | Paperwork package from Step 2 |  |  | ML | 04.01.26 | 16 |
| Qty  | Part Number                   | Description   | Batch   |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 6    | D2182B050                     | Rubber Cushion  | B19540  |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 12   | D2274                         | Radius Block  | B19599  |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 2    | D2432F                        | 24" Bearpaw   | B20081  |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 6    | D2438                         | Clamp   | B20089B |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 12   | D2529                         | Washer  | B19615  |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 6    | D2732-050                     | Rubber Cushion  | B20090  |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 12   | AN4-15A                       | Bolt  | B18806  |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 12   | AN4-17A                       | Bolt  | M13437  |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 12   | AN960JD416                    | Washer  | M12692  |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 24   | AN960JD416                    | Washer  | M13719  |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 12   | MS21042L4                     | Nut (or -4)   | M13276  |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 1    | Paperwork package from Step 2 |   |         |                      |             |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 10   | QC4                           | Inspect Kit for 100% Completeness on the W/O  | Q       | 04.01.26             | 16          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 11   | PK                            | Identify and pack for shipping as per PPP K10008  | Q       | 04.01.27             | 16          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 12   | AC                            | Cost / part 249.65  | SJC     | 04.02.02             | 16          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |
| 13   | DC                            | Close W/O 248.60<br>Inspect Level 21  | HJ      | 04.02.03             | 16          |       |   |           |                |        |    |       |              |        |   |        |             |        |   |       |       |         |    |       |        |        |   |           |                |        |    |         |      |        |    |         |      |        |    |            |        |        |    |            |        |        |    |           |             |        |   |                               |  |  |    |          |    |

| Rev | Date     | Change   | Revised By | Approved |
|-----|----------|--|------------|----------|
| F   | 02.05.22 | Chg 005 (MPP 2245)                             | NG         |          |
| G   | 02.07.11 | Replace D2639 (D2981-0200-1600) with D2732-050 | KJ         |          |
| H   | 02.08.15 | Added D427-659 to Step 2                       | KJ         |          |
| I   | 03.02.21 | Reformat; Incorporated D2432F                  | KJ/RF      |          |

| Work Order: |      | WORK ORDER CHANGES |    |      |     |                                   |                          |
|-------------|------|--------------------|----|------|-----|-----------------------------------|--------------------------|
| DATE        | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Manuf /<br>Design Mgr | Approval<br>QC Inspector |
|             |      |                    |    |      |     |                                   |                          |
|             |      |                    |    |      |     |                                   |                          |

| NCR 20081A K10008 |      | WORK ORDER NON-CONFORMANCE  |         |                                |                |                           |                        |                          |
|-------------------|------|---|---------|--------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE              | STEP | Description of NC<br>section A  | Initial | Corrective Action<br>Section B | Sign &<br>Date | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
| 04.02.02          | 5    | 1 bear paw scrap, hole misaligned - operator error.                   | AB      | Scrap destroy                  | 04.02.02       | AB<br>04.02.02            | N/A                    | AB<br>04.02.02           |
|                   |      | <del>Sylvain wanted to this shirt as he said pants were no good</del> |         |                                |                |                           |                        |                          |
|                   |      |   |         |                                |                |                           |                        |                          |

PAR#: N/AFault Category: manuf.-cncDQA: ABDate: 04.02.03QA: N/C Closed: ABDate: 04.02.03





# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Dec 16, 2003  
10:49 am

|                   |                         |                  |                |
|-------------------|-------------------------|------------------|----------------|
| Work Order No     | : 0020081               | Department Code: |                |
| Project Name      | : *K10008               | Burden Flags     | : NNNNNNN      |
| Project For       | : WK402                 | WO Status        | : Open         |
| Work Order Type   | : Main                  | Invoice State    | : Not Invoiced |
| Main WO Number    | :                       | Invoice Date     | :              |
| House Part Number | : *K10008               | Invoice Number   | :              |
| Description       | : Bearpaw kit 19" x 24" | Invoice Amount   | : 0.00         |
| Manufactured      | : Yes                   | Order Entry No   | :              |
| Amount Req'd      | : <del>20</del> 20 le   | OE Value         | : 0.00         |
| Amount Done       | : 0                     | Est Margin       | : 0.000%       |
| Start Date        | : 12-16-03              | Actual Margin    | : 0.000%       |
| Est Finish Date   | : 01-15-04              |                  |                |
| Act Finish Date   | :                       |                  |                |
| Drawings Req'd    | : No                    |                  |                |
| Ok for Approval   | :                       |                  |                |
| Approval Rec'd    | :                       |                  |                |

\$0 Posted to Finished Goods

|                   | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours | 0.00      | 0.00   | 0.00   |        |         |
| Engineering Cost  | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours  | 0.00      | 0.00   | 0.00   |        |         |
| Production Cost   | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Hours   | 0.00      | 0.00   | 0.00   |        |         |
| Packaging Cost    | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours    | 0.00      | 0.00   | 0.00   |        |         |
| OverHead Cost     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours         | 0.00      | 0.00   | 0.00   |        |         |
| CNC               | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours       | 0.00      | 0.00   | 0.00   |        |         |
| Misc.             | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Burden            | 0.00      | 0.00   | 0.00   |        |         |
| Total Cost        | 0.00      | 0.00   | 0.00   |        |         |
| Margin            | 0.000     | 0.000  |        |        |         |
| Selling Cost      | 0.00      | 0.00   |        |        |         |

|                        |           |        |
|------------------------|-----------|--------|
|                        | Estimated | Actual |
| Labour Hrs/Amount Done | : 0.00    | 0.00   |
| Profits/(Loss)         | : 0.00    | 0.00   |

|                               |  |              |        |
|-------------------------------|--|--------------|--------|
| DART AEROSPACE LTD            |  | Work Order:  | 20081A |
| Description: Bearpaw          |  | Part Number: | D2432  |
| Inspection Dwg: D2432 Rev: F3 |  | Page 1 of 1  |        |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet<br>Drawing Dimension | Tolerance     | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| A 0.063 x 45°                         | +0.030/-0.010 | 0.063 x 45°         | ✓      |        |                         |          |
| B 5.500                               | +/-0.030      | 5.517               | ✓      |        |                         |          |
| C 0.200                               | +/-0.030      | 0.200               | ✓      |        |                         |          |
| D 0.25 x 45°                          | +/-0.030      | 0.29 x 45°          | ✓      |        |                         |          |
| E R0.250                              | +/-0.030      | 0.250               | ✓      |        | RADIUS GAUGE            |          |
| F 0.250                               | +/-0.010      | 0.258               | ✓      |        |                         |          |
| G 0.625                               | +/-0.030      | 0.624               | ✓      |        |                         |          |
| H 0.375                               | +/-0.010      | 0.382               | ✓      |        |                         |          |
| I 0.950                               | +0.030/0.010  | 0.960               | ✓      |        |                         |          |
| J 19.000                              | +/-0.030      | 19.000              | ✓      |        | TAPE MEASURE            |          |
| K 3.14                                | +/-0.030      | 3.14                | ✓      |        |                         |          |
| L 3.28                                | +/-0.030      | 3.271               | ✓      |        |                         |          |
| M Ø0.260                              | +0.005/-0.000 | 0.260               | ✓      |        |                         |          |
| N Ø0.93                               | +/-0.030      | 0.92                | ✓      |        |                         |          |
| O 0.30                                | +0.030/-0.000 | 0.307               | ✓      |        |                         |          |
| P 23.750                              | +/-0.030      | 23.750              | ✓      |        | TAPE MEASURE            |          |
| Q 7.375                               | +/-0.030      | 7.376               | ✓      |        |                         |          |
| R 4.250                               | +/-0.010      | 4.243               | ✓      |        |                         |          |
| S 2.000                               | +/-0.030      | 2.019               | ✓      |        |                         |          |
| T 9.000                               | +/-0.010      | 9.000               | ✓      |        |                         |          |
| U 9.000                               | +/-0.010      | 9.000               | ✓      |        |                         |          |
| V 0.375                               | +/-0.010      | 0.381               | ✓      |        |                         |          |
|                                       |               |                     |        |        |                         |          |
|                                       |               |                     |        |        |                         |          |
|                                       |               |                     |        |        |                         |          |

|                        |                       |                     |     |
|------------------------|-----------------------|---------------------|-----|
| Measured by: <u>GP</u> | Audited by: <u>R</u>  | Prototype Approval: | N/A |
| Date: <u>04/01/23</u>  | Date: <u>04.01.23</u> | Date:               |     |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 04.01.09 | New Issue | KJ/RF      | <u>#</u> |

RELEASED

04.01.15

